

Work Order ID 109204

109204

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November-14-13 11:50:01 AM

Item ID: D4839-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Blade

Start Date: 11/14/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 11/14/13 Req'd Qty: 2.00 *2*

Customer:

Reference: Rework

Approvals: Process Plan: u Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4839	REV A

100

0.00

100

Packaging

Memo

0.00

Packaging

4 X PULL FROM STOCK:
X 646.9711 B 102756

RE-IDENTIFY AS D4839-1

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

DAS
27
9-89

B 11.15

120

Identify as per dwg & Stock Location: composites 0.00

120

Packaging

Memo

0.00

Packaging

(Finishing)

Work Order ID 109204

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Item ID: D4839-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade

Start Date: 11/14/13 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 11/14/13 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

13/11/18

MF
13-11-19

Picklist Print

November-14-13 11:52:04 AM

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Work Order ID: 109204
 Parent Item: D4839-1
 Parent Item Name: Blade

Start Date: 11/14/13 Required Date: 11/14/13
 Start Qty: 4.00 Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9711 Blade		Manufactured	No				Each	235.0000		8	4	11-11-15	

Location	Loc Qty	Loc Code
CA	234	
100268	97	
102756	60	
98911	77	
ST437	1	
91807	1	

4

8 7 6 5 4 3 2 1

D

C

B

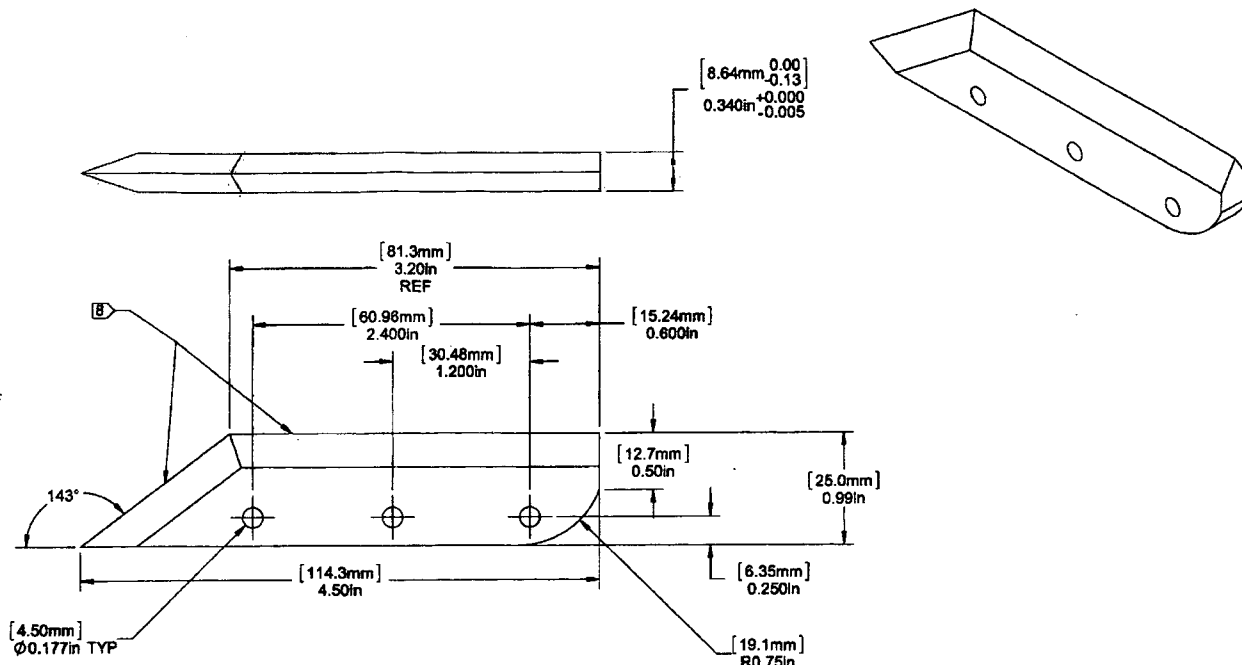
A

D

C

B

A



D4839-1 BLADE

RELEASED
2013-07-12
140

Mo 109224 h

NOTES:

- 1) MATERIAL: AISI A2 TOOL STEEL PER ASTM A681 (DART SPEC MSTEEL-A2-B0.375X4.500)
CONDITION: ANNEALED (HEAT TREAT TO 68-62 ROCKWELL C HARDNESS) PER MIL-T-6736 OR AMS2759/1E
- 2) FINISH: PRIME IAW MIL-P-23377J TYPE1, CLASS N: 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs (0.13 kgs)
- 8) DO NOT BREAK EDGE OF BLADE, INTENDED TO BE SHARP
- 9) REFERENCE APICAL PART NUMBER 646.9711

A NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION		BY DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	21	D4839	SHEET 1 OF 1
APPROVED	21	TITLE	SCALE
DE APPR.	21	BLADE	NTS
DATE	13.05.23	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1